IN THE SPECIFICATION

Amend the Specification a follows:

[0003] Some steam turbine design concepts ~~employee~~ employ diaphragms, which are conventionally formed by inserting opposed ends of blades into cutouts in semi-circular bands known as spacers. The ends of the blades are tack welded to the spacers and outer and inner semi-circular rings are penetration welded to the spacers and to the blades. In order to obtain satisfactory attachment of the blades to the rings, very deep welding is necessary between the rings and spacers so that the weld penetrates far enough in this interface to also contact and attach the blades.

[0016] FIG. 2 is a side perspective view of an integral covered nozzle (~~INC~~ ICN) in accordance with an exemplary embodiment;

[0024] Referring now to Figure 3, three ICN's 100 are shown coupled together via facing sides 118 and include ~~a overcover or overcover~~ an overcover 110 disposed over each of the cover portions 106. It is contemplated that overcover 110 is disposed over multiple ICN's 100 such that multiple means more than one, including two or more ICN's100. Overcover 110 is preferably configured having a thickness less than each respective cover portion 106. Overcover 110 includes apertures positioned therein to align with a tenon 108 extending from each cover portion 106. Each tenon 108 is peened down to retain the overcover 110 which spans across the three nozzles 100 shown. However, any number is contemplated including two nozzles 100 to a number that would complete a ring around shaft 14. Each tenon 108 may be any shape or size and is no longer limited to the shape of the airfoil tip generally shown in FIG. 5 – which typically is restrained to fall within the geometry of the airfoil tip in which it is secured. Other methods of retaining overcover 110 may also be used, such as brazing or welding. If brazing or welding is used for attachment of overcover 110 to cover portions 106, a tenon 108 on cover portions 106 may or may not be used to facilitate this process.

[0025] In an exemplary embodiment and referring again to FIG. 2, a material buildup in the form of a weld buildup or, alternatively, braze, plating, spraying or other mechanical means or metallurgical means is applied to each one of the facing sides 118 of the cover ~~portion~~ portions 106. The material buildup 119 is illustrated in FIG. 2 in phantom. Machining is effected

to remove excess material 120 from the buildup portion 119 and thereby provide a clean contacting interface 121 between adjacent cover ~~portion~~ portions 106 (See FIG. 5). Excess material 120 is on an outer circumferential face portion 122 of the cover portion 106 and also on an inner circumferential face portion 123 of each cover portion 106.

[0026] The interface 121 can have different interlocking shapes. In FIG. 4a, interface 121 is illustrated as a Z-cut. In FIG. 4b, the interface 121 is a straight line rectangularly directed relative to the turbine blading and parallel to the rotor's rotational axis. In FIG. 4c, the interface 121 is a double wing or nested construction. This is a construction which has curves directed towards both the trailing edge 124 and leading edge 125 of a turbine blade. In FIG. 4d, a single wing design is illustrated such that the interface 121 has only a single curve 126 in the direction of the trailing edge 124. In FIG. 4e, the interface 121 is a diagonally directed line. The interface is of a nature such that a snug fit can be achieved between adjacent cover ~~portion~~ portions 106. In this manner, a contact at the interface line 121 between neighboring blades or nozzles 100 occurs so that if any blade 104 attempts to vibrate, its motion is dampened by the neighboring blade 104. The example of FIG. 4b is likely the most effective structure since, as the blades try to twist due to a nozzle wake frequency, these rectangular shaped cover ~~portion~~ portions cause an increase in pitch as the frequency increases.

[0027] Referring to FIG. 5, individual cover ~~portion~~ portions 106 are assembled on blades 104 and then tack welded at 132 to allow the tenons 108 to be riveted without the cover ~~portion~~ portions 106 moving. After the riveting of tenons 108 to the cover ~~portion~~ portions 106 is effected, excess extension material 133 which runs along the edges of each cover portion 106 is removed. In this manner, the tack weld sections 132 are trimmed off on opposite sides (only one side shown in FIG. 5) leaving integral cover ~~portion~~ portions 106 affixed to each blade 104.

[0028] In different embodiments of the invention, integral covered blading can be constructed initially in this manner. Thus, cover ~~portion~~ portions 106 can be affixed to the tips 111 of each blade 104 by suitable welding or brazing. Thereafter, each blade structure constitutes an equivalent integral covered nozzle.